

Date: Tuesday, 4/4/2006 1:32:36 PM
 User: Kim Johnston

Process Sheet

Split
06/05/15

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 26514-	
Estimate Number : 10911	
P.O. Number : N/A	Part Number : D3405041
This Issue : 4/4/2006 S.O. No. : N/A	Drawing Number : D3405 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : N/A	Material : N/A
	Due Date : 4/27/2006
Written By : <i>SEE COMMENT BELOW</i>	Qty: <i>10</i> Um: Each
Checked & Approved By : <i>06.04.04</i>	
Comment : Est A 05.09.01 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *452*
 Email or Ship DXF file to vendor
 Laser Cut flat pattern per Dwg D3405
 Material release note is required
 Identify as D3405-1

C Log 104/06 (30)

2.0	D34051F	GHW Bracket
-----	---------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
 G H W BRACKET

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK
 Inspect dimensions as per Dwg D3405

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Deburr
 Form using DT8204 as per Dwg D3405

SAD 06104;22 30

M.F. 06.05.13

SB

06/05/15

(30)

(10)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 26514

Part Number: D3405041

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-05-16

(10)

Comment: INSPECT WORK TO CURRENT STEP

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

B26775

A/R

SS Rod

M18712

06/05/16 (10)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

06/05/16 (10)

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06-05-16 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06-05-17 (10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/05/17 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 577

06/05/17 (10)

Tuesday, 4/4/2006 1:32:37 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 26514

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Handwritten: 06/05/18 (10)

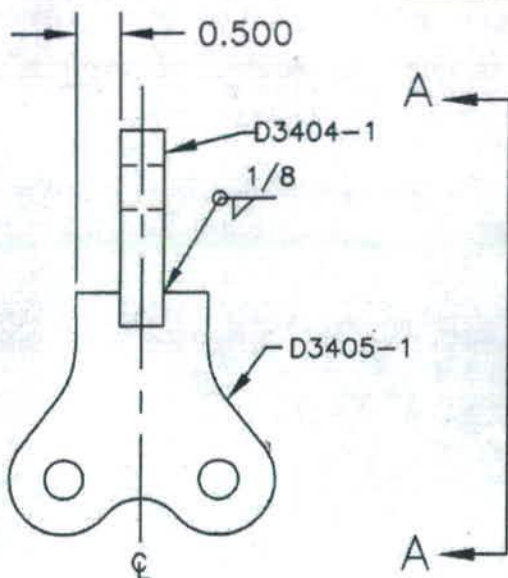
Job Completion



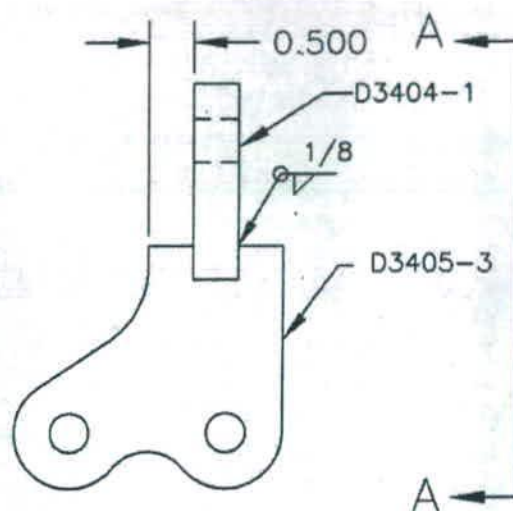
Handwritten: 06-05-18



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08		TITLE GHW LUG ASSEMBLY	SCALE 1:2
A	05.03.08	NEW ISSUE	



D3405-041 LUG ASSEMBLY

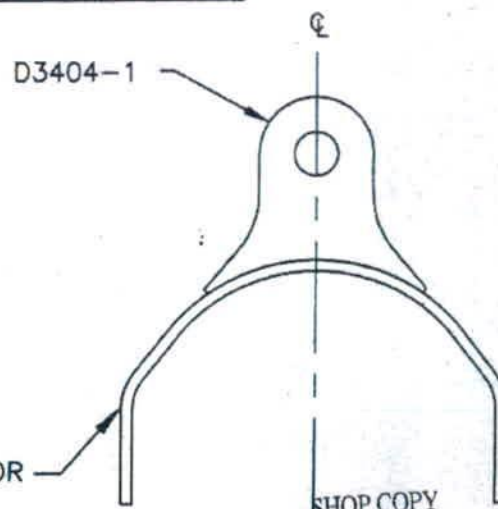


D3405-043 LUG ASSEMBLY

PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09



D3405-1 OR
D3405-3

SHOP COPY
RETURN TO
VIEW A-A
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26514

D3405-041/-043 LUG ASSEMBLY

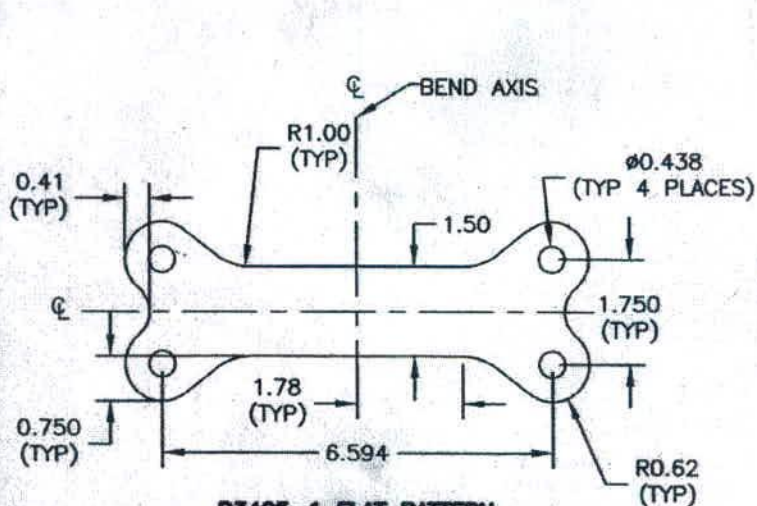
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

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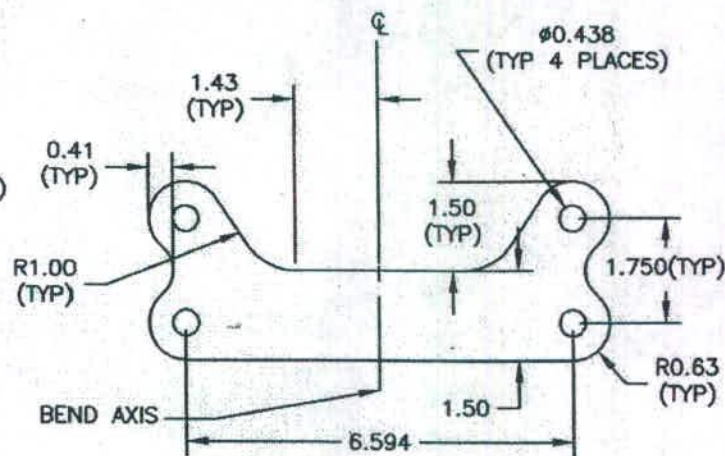
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DART

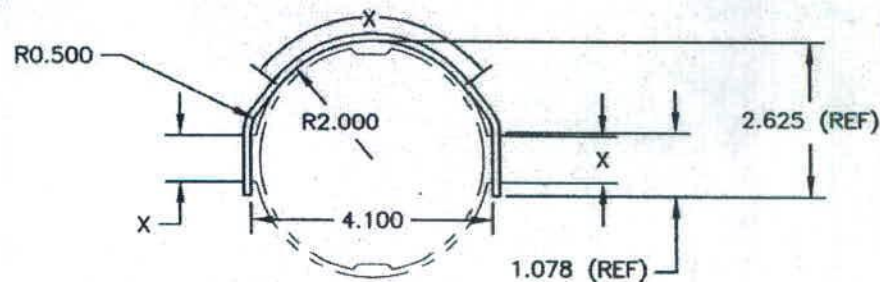
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.03.08	DRAWING NO.	D3405	REV. A
		TITLE	GHW LUG ASSEMBLY	SHEET 2 OF 2
				SCALE 1:3



D3405-1 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-3 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-1 AND D3405-3 BEND DETAIL
D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1/-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-08-08
SUBJECT TO ADDENDUM
WITHOUT NOTICE

NO. 26514
WORK ORDER

90277641

MATERIAL TEST/INSPECTION CERTIFICATE



YIEH MAU CORP.

INVOICE NO. : 905MC11

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

工廠: 高雄路竹竹脚聯合路545號
 318, SHUN AN RD. LU CHU HSIANG
 KAOHSIUNG TAIWAN R.O.C.
 TEL: (07) 272885 FAX: (07) 2973065
 CERTIFICATE NO. 905MC11
 DATE OF ISSUE: 01/02/2008
 PAGE: 1

SPECIFICATION : AISI 304

CUSTOMER : INTEGRIS METALS LTD.

ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	SI NO.	Physical Properties Tensile Test CL=50mm					Chemical Composition (%)							
			KGM	LBS			YS	TS	EL	APH	RV	C	Si	Mn	P	S	Al	Cr	Ni
							(MPa)	(MPa)	(%)			(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)
AISI 304, 2B FINISH, WITH PAPER INTERLEAVED, SLITTED EDGE																			
7427-4085	12GA160"X 96"	1	1,444	3,183	YU140116	4B820312B-213	299	666	60	88	164	4.7	48	124	32	8	608	1620	2.8
7427-4085	12GA160"X 96"	1	1,445	3,186	YU140116	4B820312D-11	299	666	60	88	164	4.7	48	124	32	8	608	1626	2.8
7427-4127	12GA160"X 120"	1	1,141	2,515	YU140116	4B820313C-12	299	666	60	88	164	4.7	48	124	32	8	608	1620	2.8
7427-4127	12GA160"X 120"	1	1,141	2,515	YU140116	4B820313C-13	299	666	60	88	164	4.7	48	124	32	8	608	1620	2.8
7427-4127	12GA160"X 120"	1	1,141	2,516	YU140116	4B820313C-14	299	666	60	88	164	4.7	48	124	32	8	608	1626	2.8
7427-4127	12GA160"X 124"	1	1,141	2,516	YU140116	4B820313C-15	299	666	60	88	164	4.7	48	124	32	8	608	1626	2.8
7427-4127	12GA160"X 124"	1	1,473	3,247	YU140209	4B820317B-18	306	677	60	84	166	4.8	56	120	35	6	606	1610	8
7 8.926 19.576																			
NO MEMORY CONTAMINATION																			
Send test record for all Heat NO.																			

